

Date: Wednesday, 06/09/2006 11:05:08 AM  
 User: Linda Lacelle

## Process Sheet

|                       |                                       |                  |                                  |
|-----------------------|---------------------------------------|------------------|----------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : GPS RECEIVER HOUSING           |
| Job Number            | : 28419                               | Part Number      | : D35147                         |
| Estimate Number       | : 12494                               | Drawing Number   | : UNDER REVIEW <i>E 06.09.05</i> |
| P.O. Number           | : N/A                                 | Project Number   | : N/A                            |
| This Issue            | : 06/09/2006 S.O. No. : N/A           | Drawing Revision | : N/A                            |
| Prsht Rev.            | : NC                                  | Material         | : N/A                            |
| First Issue           | : N/A Type : SMALL /MED FAB           | Due Date         | : 13/09/2006                     |
| Previous Run          | : N/A                                 | Qty:             | 1 Um: Each                       |
| Written By            | : <i>E</i>                            |                  |                                  |
| Checked & Approved By | : _____                               |                  |                                  |
| Comment               | : Est Rev:A New Issue 06-07-26 JLM    |                  |                                  |

Additional Product

PRELIMINARY ISSUE

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.2518 sf(s)/Unit Total : 0.2518 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *MTS 380**MM 06 09 07*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *Pre*Prog Rev: *Pre**MM 06 09 07**(1)*

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary

*MM 06 09 07**(1)*

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MM 06 09 07**(1)*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*SD 06.09.07**(1)*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/07/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28419

Part Number: D35147

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form Joggle as per Dwg D3514

SB 06/09/07

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe 06-09-07 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 06-09-06-09-12

①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 06-09-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock For Eng. use only

Location: \_\_\_\_\_

E 06-07-19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

D 07/07/04 ①

Job Completion



u 06-09-20

Eng Approval

CB 07.03.08

PART NOT MARKED AS PROTOTYPE. PART WENT TO HAI.  
PART IS NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

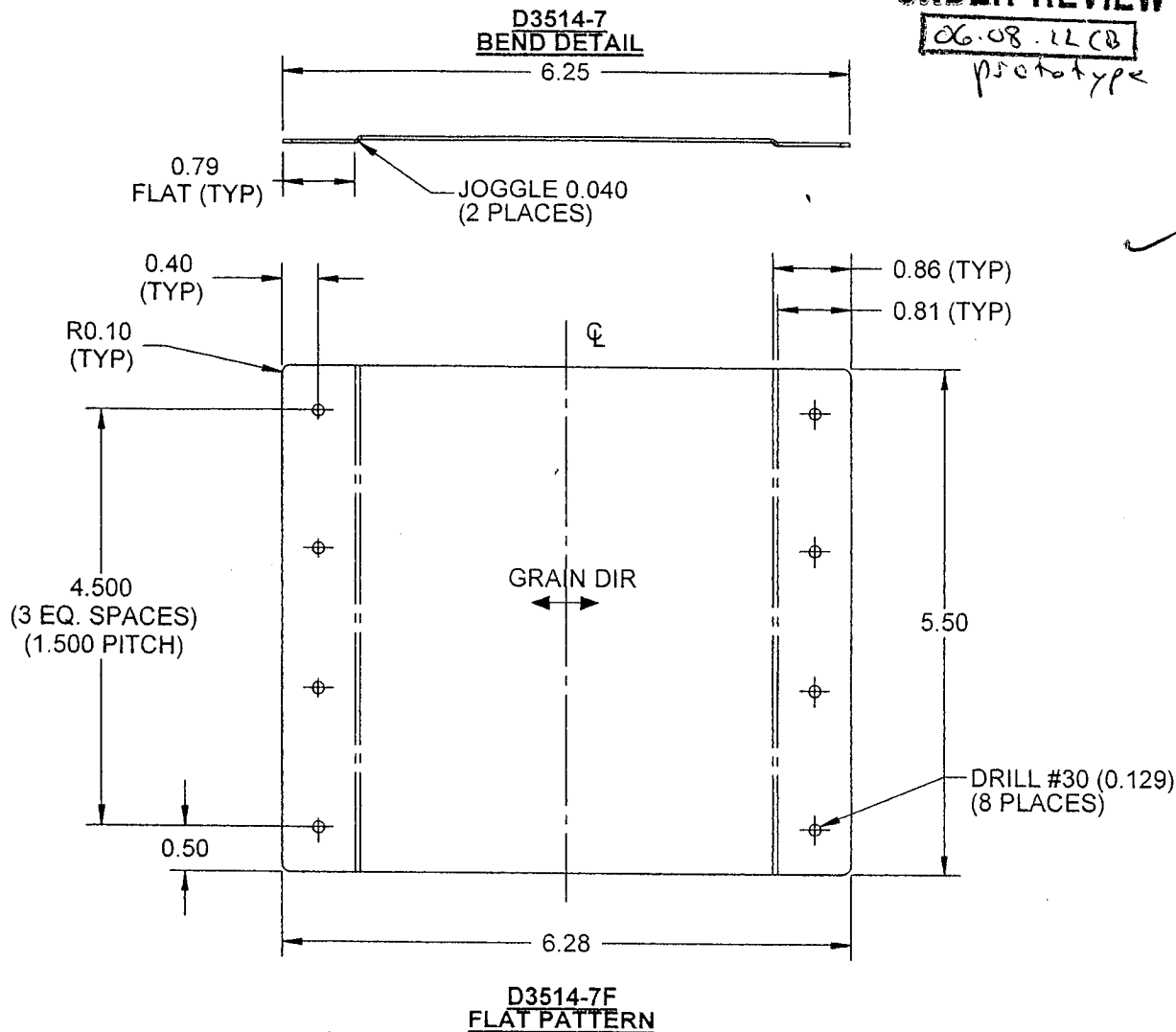
PRELIMINARY ISSUE

|                  |                |   |              |
|------------------|----------------|---|--------------|
| DESIGN<br>CB     | DRAWN BY<br>CB | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED          | APPROVED       | DRAWING NO.<br>D3514                              | REV. A       |
| DATE<br>06.05.03 |                | TITLE<br>GPS RECEIVER HOUSING                     | SHEET 6 OF 7 |
|                  |                |   | SCALE<br>1:2 |

UNDER REVIEW

06.08.12 CB

prototype



**D3514-7 BOX BOTTOM (TOP MOUNTED)**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040" SHEET  
(REF: DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT  $\phi$

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DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES  
CORPORATE SERVICES DIVISION  
SOUTHFIELD, MI USA

Corus Aluminium N.V.  
A. Stodelaan 87, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)  
ONS ORDERNUMMER : 58848/01  
DOCUMENT NUMBER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC.) AA 5061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04  
AFMETINGEN : 144" X 48" X 0.04"  
ARTIKEL NR.:

| ROL-<br>NUMMER |         | GEUT-<br>NUMMER |            | CHEMISCHE ANALYSE (%) |                    |            |                  |                    |            |            |
|----------------|---------|-----------------|------------|-----------------------|--------------------|------------|------------------|--------------------|------------|------------|
|                |         | MIN             | SI<br>0,40 | FE<br>0,7             | CU<br>0,15<br>0,40 | MN<br>0,15 | MG<br>0,8<br>1,2 | CR<br>0,04<br>0,35 | TI<br>0,15 | ZN<br>0,25 |
| 001            | 7124901 |                 | 0,67       | 0,4                   | 0,22               | 0,09       | 1,1              | 0,16               | 0,02       | 0,01       |
| 002            | 7124901 |                 | 0,67       | 0,4                   | 0,22               | 0,09       | 1,1              | 0,16               | 0,02       | 0,01       |
| ANDERE : ELK   |         |                 |            | :                     | MIN                | 0,05 MAX   |                  |                    |            |            |
| TOTAAL         |         |                 |            | :                     | MIN                | 0,15 MAX   |                  |                    |            |            |

| TEST-<br>NUMMER |    | MECHANISCHE EIGENSCHAPPEN                             |     |           |             |        |
|-----------------|----|---|-----|-----------|-------------|--------|
|                 |    | 1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI |     |           |             |        |
|                 |    | /A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM         |     |           |             |        |
|                 |    | MIN   | MAX | RM<br>KSI | RP02<br>KSI | A<br>% |
|                 |    |   |     | 42        | 35          | 10     |
| 001             | /A |   |     | 47        | 39          | 16     |
| 001             | /M |   |     | 47        | 39          | 15     |
| 001             | /V |   |     | 47        | 39          | 16     |
| 002             | /A |   |     | 47        | 39          | 16     |
| 002             | /M |   |     | 48        | 40          | 16     |
| 002             | /V |   |     | 48        | 39          | 16     |

COPPER AND BRASS SALES  
SOLD TO: 0 73

19380

COPPER AND BRASS SALES

SOLD TO: C & BDATE: 12/16 QTY. 20CUSTOMER PO: 00000024SHIPPER NO: 4V3128BY: 8

Corus Aluminium Rolled Products - Corus Aluminium Extrusions